

Process Sheet

POSITIVE RECALL

Date: Friday, 5/25/2007 8:36:53 AM
User: Kim Johnston

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : ARM

EFFECTIVE 07.06.05 AUTH GP

Job Number : 32648 - 4

RELEASED 07.06.06 DATE GP

Estimate Number : 12884

P.O. Number : N/A

Part Number : D3560044

This Issue : 5/25/2007

S.O. No. : N/A

Drawing Number : D3560 REV.B

Prsht Rev. : NC

Project Number : N/A

First Issue : N/A

Type : SMALL / MED FAB

Drawing Revision : B

Previous Run : N/A

Material : N/A

Due Date : 6/5/2007

Qty: 30 Um: Each

Written By : GPChecked & Approved By : GP 07.05.25

Comment : Est Rev:A New Issue 07.05.24 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M6061T6B0500X05000

6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total : 40.7925 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: 7625 M104598 x20BC07.06.0120

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long

BC07.06.0120

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: 14 & Dwg D3560 Rev: B

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

JL/BC07.06.0120

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/BC07.06.0120

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

GP07.06.1120

19

WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.06.06	11	NO POWDER COAT. CHEM CONV. COAT ONLY. REF ATTACHED ITS EMAIL				UP 07.06.06 Per 451097	07.06.11
07.06.28	11	D 2808 Butch B32752 Part Bursing		07.06.27	6	U 07.06.16	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/10
QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/10	3	- 1 part scrapped, part wasn't clamp tight enough causing blank to shift move while machining on 1st app	Q51042	Scrap + replace destroy	JL 07/06/10	07/06/11	Q51042	07/06/11
07/06/22	8.0	Qty 6 parts have cracks on the 03592-1 plate, due to too much heat transfer to gain deeper penetration during welding. R.C.: Too hot of a weld on the plate. human error	Q51042	- Remove the 03592-1 plate and grind any access weld flush verify part by Q.C. Pick new 03592-1 034478 weld plate as per Dwg Scrap; destroy no replace	07/06/23 a.m. 07/06/01	07/06/22	Q51042	07/06/22

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 7:40:40 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32648

Part Number: D3560044

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
6.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
7.0	D35921	PLATE
Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s) PLATE 3.32666 3.32661		
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Weld assembly as per dwg D3560		
9.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
10.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		
11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
12.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		

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Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

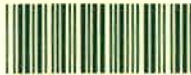


Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

17.0

EMP COST ADJ

Employee Labour Cost Adjustment

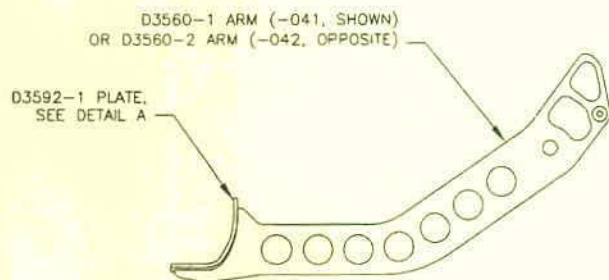


Comment: Sub-Contracting Employee Labour Cost Adjustment

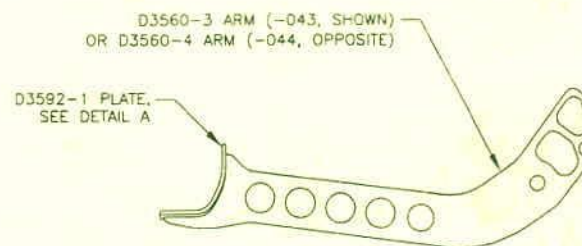
Job Completion



h 07-10-02

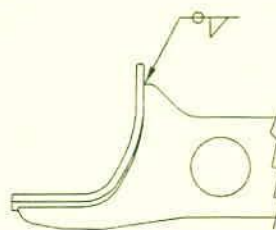
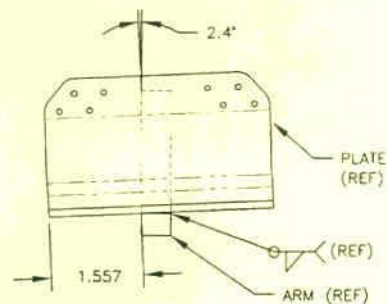


D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)

W/C 32648



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

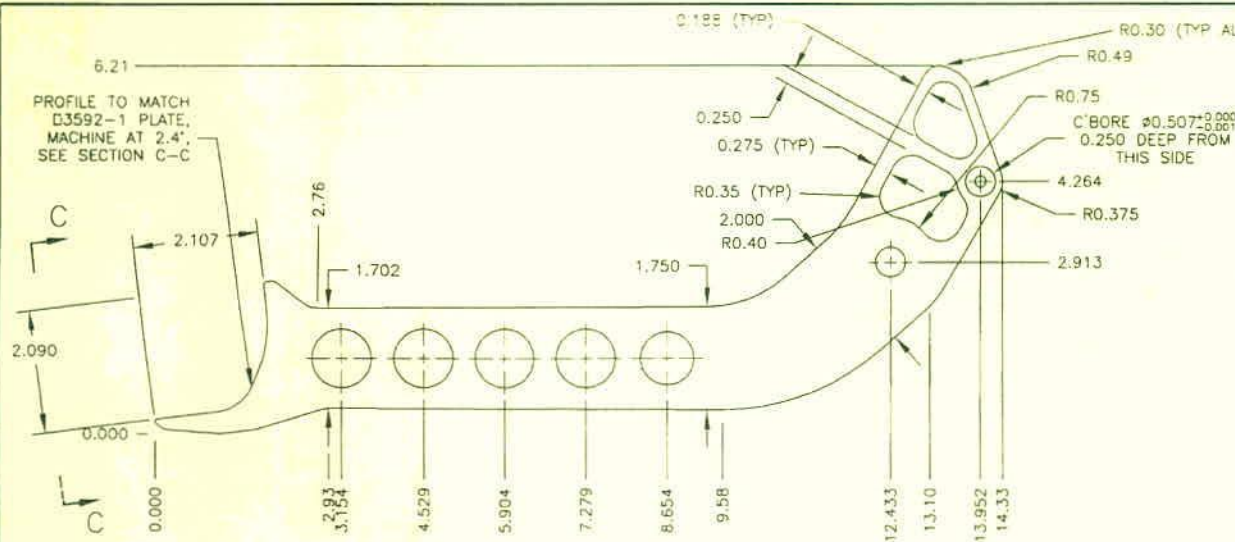
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07.06.19

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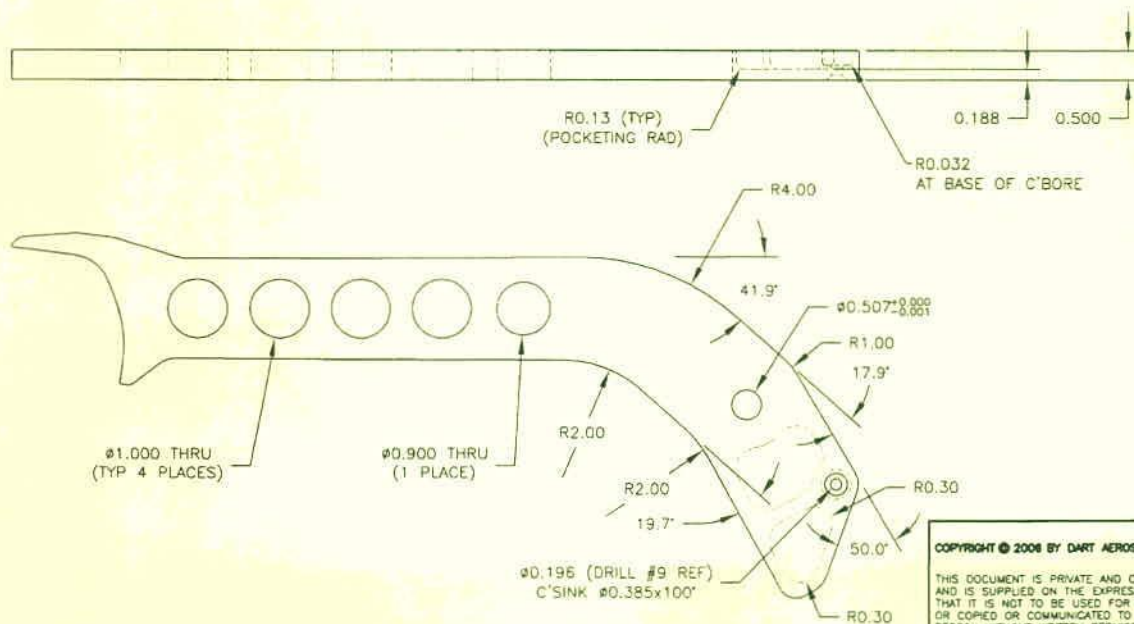
C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE		TITLE ARM WELDMENT
07.06.19		1/4

REV. C
SHEET 1 OF 3



D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061TEB0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



RELEASED
07.06.19

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DESIGN	qf	DRAWN BY	qf	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	th	APPROVED	th	DRAWING NO.	REV. C
DATE	07.06.19	TITLE	ARM WELDMENT	D3560	SHEET 3 OF 3
		SCALE	1:2		

